

Date: Friday, 2/23/2007 8:31:43 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HINGE BRACKET
Job Number	: 30885		
Estimate Number	: 10345		
P.O. Number	: <u>N/A</u>	Part Number	: D28571
This Issue	: 2/23/2007 S.O. No. : <u>N/A</u>	Drawing Number	: D2857 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <u>N/A</u> Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 29051	Material	: <u>N/A</u>
Written By	: <u>JA 07.02.23</u>	Due Date	: 3/24/2007 Qty: 24 Um: Each
Checked & Approved By	: <u>JA 07.02.23</u>		
Comment	: Est C 08.06.22 Removed P/O for powder coat EC		
	: Est D 06.05.01 Added level 8 EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	M6061T6B2000X01250	6061-T6 Bar 2.0" x 1.25"
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Comment: Qty.: 0.4594 f(s)/Unit Total: 11.0250 f(s)

Material: 2.00" X 1.25"

6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8)

(M6061T6B200001250)

Batch M18818/8PCSM100451/17PCSJ.F. 07/03/1625

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blanks 5.2"

J.F. 07/03/1625

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine per folio D2857-1

J.L / J.F.07/03/1725

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L / J.F.07/03/1725

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 2 Date: 07/03/23  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 2/23/2007 8:31:43 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 30885

Part Number: D28571

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*mk 07/03/18 25*

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

2-Deburr any rough edges after tumbling

*JB 07/03/20 25*

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.3

*HS/mk 07-03-20 25*

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*mk 07/03/20 (25)*

9.0

POWDER COATING

POWDER COATING 1



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3

*mk 07/03/20 (25x)*

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*mk 07/03/21 (25)*

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*mk 07/03/21 (25)*

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*mk 07/03/23 (25)*

Job Completion



*u 07/03/24*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	30885
<b>Description:</b> Hinge Bracket		<b>Part Number:</b>	D2857-1
<b>Inspection Dwg:</b> D2857 <b>Rev:</b> A/B		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010	4.302	✓			
0.340	+/-0.010	.340	✓			
1.110	+/-0.005	1.110	✓			
1.790	+/-0.010	1.792	✓			
1.320	+/-0.005	1.320	✓			
2.000	+/-0.010	2.002	✓			
Ø0.171	+0.005/-0.000	.173	✓			
0.147	+/-0.010	.140	✓			
0.376	+/-0.010	.376	✓			
0.126	+/-0.010	.125	✓			
0.063	+/-0.010	.062	✓			
Ø0.166	+0.005/-0.000	.167	✓			
0.911	+/-0.010	.913	✓			
0.600	+/-0.010	.606	✓			
0.125	+/-0.010	.135	✓			
0.150	+/-0.010	.153	✓			

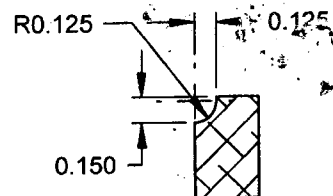
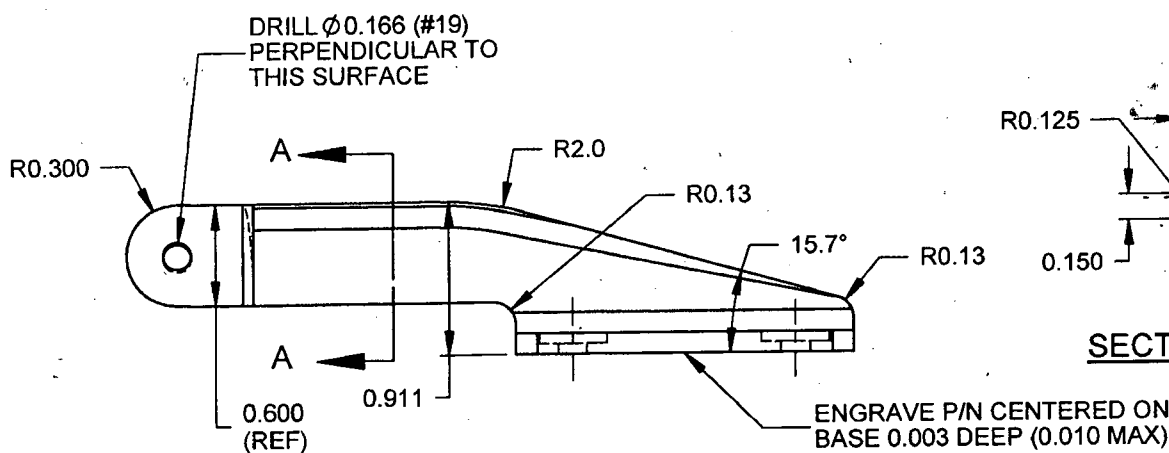
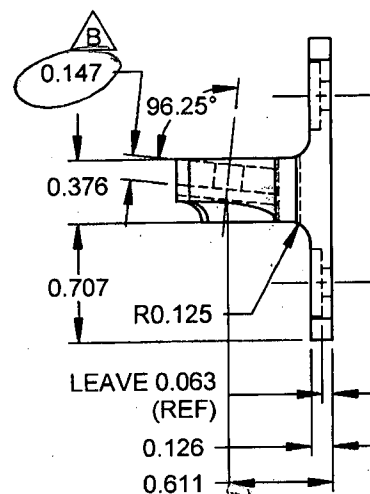
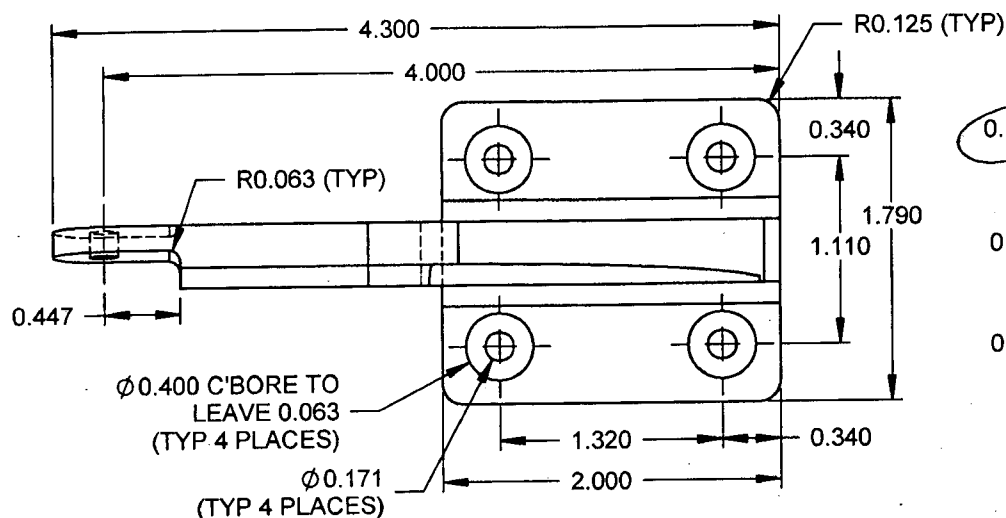
<b>Measured by:</b>	JL	<b>Audited by:</b>	JML	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	07/03/17	<b>Date:</b>	07/03/17	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	<i>[Signature]</i>



DESIGN KE	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2857	REV. B SHEET 1 OF 1
DATE 06.08.28	TITLE HINGE BRACKET		SCALE 1:1
REV	DATE	DESCRIPTION	
A	98.12.14	NEW ISSUE	
B	06.08.28	ADD THICKNESS, REDRAW W/ SOLIDWORKS	

RELEASED  
06-10-13

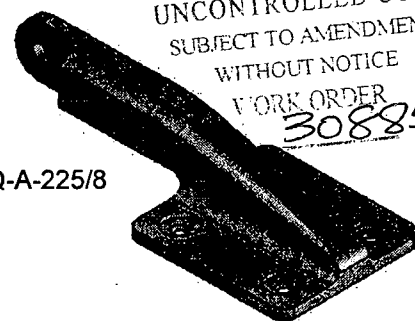


SECTION A-A

**D2857-1 HINGE BRACKET**  
**D2857-2 OPPOSITE**

**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX



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WORK ORDER  
30885

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